

Work Order ID 160453

Thursday, April 27, 2017 3:36:28 PM

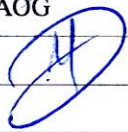
160453**U/R**

OK d' 7/4/28

Page 1

Item ID: D145-762-015 **Accept**
Revision ID: URF 17-547
Item Name: Skidtube, Std Wearplates, DART (Apical) Tri-Bag Float Compatible, Fits LH or RH
Start Date: 5/8/2017 **Start Qty:** 1.00 ***1***
Required Date: 5/11/2017 **Req'd Qty:** 1.00 ***1***
Reference: SCHEDULED/C AOG

N900040100**Setup Start *NS1*****Stop *NS2*****Cust Item ID:****Customer:**

Approvals: **Process Plan:**  **Date:** APR 27 2017 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1***Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D117-762	E

DAS
6
9-89

APR 28 2017

100

0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D145-762-015 CHG002

★ PRO

DAS
28
9-89

MAY 17 2017

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

DAS
27
9-89

APR 29 2017

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS
28
9-89

MAY 19 2017

B160464

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐					
Date : <u>17/4/28</u>		Step #: <u>100</u>		QTY Effective :			MRB (QSI042) Approval <u>DAS</u> <u>12</u> <u>9-89</u> <u>17/4/28</u>		
Description Work Order Deviation				Disposition				Completed By	
Red deccl must add reference to DSI 9775-011 & CHG 001 & B/N				" w/ DSI 9775-011 " Add " DSI 9775-011 CHG 001 B/N " To red deccl. Ensure DSI 9775 Rev.A is included in paperwork.				Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

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Page 2

Item ID: D145-762-015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 17-547 Stop ***NS2***
Item Name: Skidtube, Std Wearplates, DART (Apical) Tri-Bag Float Compatible, Fits LH or RH
Start Date: 5/8/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/11/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C AOG

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D145-762-015 Location: <u><i>Sold</i></u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

[Signature] MAY 19 2017

[Signature] MAY 19 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By 					
				Lead hand / Supervisor Approval Verification 					
				QC / QA Coordinator Approval 					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

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Work Order ID: 160453

160453

Parent Item: D145-762-015

D145-762-015

Parent Item Name: Skidtube, Std Wearplates, DART (Apical) Tri-Bag Float Compatible, Fits LH or RH

Start Date: 5/8/2017

Required Date: 5/11/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.24 NEW ISSUE DD VERF:JLM IPP
REV:B 16.02.05 IIN REV.E (ecn16-514) DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D145-762-045		Manufactured	No			110	Each	0.0000	1	1		DAS 8 9-89	
D145-762-045									**	160463		APR 29 2017	DAS 27 9-89
Replacement Float Skidtube													
D145-762-055		Manufactured	No			110	Each	0.0000	1	1		DAS 8 9-89	
D145-762-055									**	160466		APR 29 2017	DAS 27 9-89
Repl. Wearplates for Skidtubes, DART (Apical) Tri-Bag Float Comp., Fits LH or RH													
AN6C52A		Purchased	No			110	Each	11.0000	2	2		DAS 6 9-89	
AN6C52A									**			APR 29 2017	DAS 27 9-89
BOLT													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST333	11				2			
					m134535	11							
D5300-1		Manufactured	No			110	Each	4.0000	2	2		DAS 8 9-89	
D5300-1									**			APR 29 2017	DAS 27 9-89
GHL Bushing													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST162	4				2			
					156514	4							
D5301-1		Manufactured	No			110	Each	2.0000	2	2		DAS 6 9-89	
D5301-1									**			APR 29 2017	DAS 27 9-89
GHL Plug													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST162	2				2			
					156516	2							

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 160453

160453

Parent Item: D145-762-015

D145-762-015

Parent Item Name: Skidtube, Std Wearplates, DART (Apical) Tri-Bag Float Compatible, Fits LH or RH

Start Date: 5/8/2017

Required Date: 5/11/2017

MS21043-6

Purchased

No

110

Each

120.0000

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

NUT

2

2

DAS
8
9-89

DAS
27
9-89

APR 29 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

100

m135470

2

m137361

98

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

5.3 D145-762-015/-115 Skidtube Parts List

Item	Qty -015	Qty -045	Qty -055	Qty -115	Qty -155	Part Number	Description
	X					D145-762-015	FLOAT SKIDTUBE WITH STD WEARPLATES
	1	X		1		D145-762-045	REPLACEMENT FLOAT SKIDTUBE
	1		X			D145-762-055	REPLACEMENT WEARPLATES (FLOAT SKIDTUBES)
				X		D145-762-115	FLOAT SKIDTUBE WITH TRAINING WEARPLATES
				1	X	D145-762-155	REPLACEMENT TRAINING WEARPLATES (FLOAT SKIDTUBE)
201		1				D4766-041	SKIDTUBE ASSEMBLY
202	2			2		**L321M1024101 OR **B321M1026101	SKID SHOE (REF ONLY)
203	8			8		**BRSP96/25-SK-W5-1 TEILIG OR **BRSP98/25-SK-W5-1 TEILIG OR **01618266098	CLAMP (REF ONLY)
204	8			8		**N/A	OEM BOLT (REF ONLY)
205	8			8		**N/A	OEM LOCKING WASHER (REF ONLY)
206	8			8		**N/A	OEM WASHER (REF ONLY)
210A		1				*D2965	CAP
210B		1				*D2965-3	CAP
211		4				***AELS-1032-225	INSERT
212		2				*AN3C5A	BOLT
213		2				*NAS1149C0332R	WASHER (OR AN960C10L)
214		2				*AN526C1032	SCREW
220A			1			D4682-041	WEARPLATE
220B			1			D4682-045	WEARPLATE
220C			1			D4682-11	WEARPLATE
221A					1	D4769-041	WEARPLATE
221B					1	D4772-041	WEARPLATE
221C					1	D4771-041	WEARPLATE
222			6		6	D4764-1	BUSHING
223			12		12	D4764-5	BUSHING
224			1		1	AN4C42A	BOLT
225			2		2	AN4C43A	BOLT
226			2		2	AN6C44A	BOLT
227			4		4	AN6C45A	BOLT
228			3		3	MS21043-4	NUT
229			6		6	MS21043-6	NUT
230		3				*AELS-1032-130	INSERT
231		3				*AN3C4A	BOLT
232		3				*NAS1149C0332R	WASHER (OR AN960C10L)
250	2			2		AN6C52A	BOLT
251	2			2		D5300-1	GHL BUSHING
252	2			2		D5301-1	GHL PLUG
253	2			2		MS21043-6	NUT

* PART IS INCLUDED WITH D4766-041 STD SKIDTUBE ASSEMBLY
 ** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY
 *** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

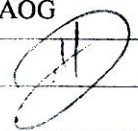
OK 4/17/17

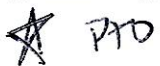
Work Order ID 160453

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Thursday, April 27, 2017 3:36:28 PM

Page 1

Item ID: D145-762-015 Accept *N900040100* Setup Start *NS1*
Revision ID: URF 17-547 Stop *NS2*
Item Name: Skidtube, Std Wearplates, DART (Apical) Tri-Bag Float Compatible, Fits LH or RH
Start Date: 5/8/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 5/11/2017 Req'd Qty: 1.00 *1* Customer:
Reference: SCHEDULED/C AOG
Approvals: Process Plan:  Date: APR 27 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-762	E	APR 28 2017							
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D145-762-015 CHG002								
									
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

CB

17-05-01